

Work Order ID 58218

April 29, 2010 11:19:04 AM

Page 1

Item ID: D3262-043

Accept

Revision ID:

Item Name: Canister Assembly

Start Date: 4/29/10 Start Qty: 1.00

Required Date: 4/30/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

D

100

Weld per dwg A/R Aluminum rod Batch: *m113207*
Large Fab *m112860*

0.00

Large Fab

Memo

0.00

Large Fab

Weld canister assembly as per Dwg D3262 using DT8739 to align fittings

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O 0.00

QC

Memo

0.00

Quality Control

Pressure test as per Dwg D3262

BE 10/04/30

① PD 10.05.03

Sub 103

②

Work Order ID 58218

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Page 2

Item ID: D3262-043

Accept

Revision ID:

Item Name: Canister Assembly

Start Date: 4/29/10

Start Qty: 1.00

Required Date: 4/30/10

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

①

BR 10-5-3

140

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

****Ensure to mask threads ****
START TIME: 7:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 7:30AM

=> M

10/05/01

1

Ø

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

①

BR 10-5-4

Work Order ID 58218

April 29, 2010 11:19:05 AM

Page 3

Item ID: D3262-043

Accept

Revision ID:

Item Name: Canister Assembly

Start Date: 4/29/10

Start Qty: 1.00

Required Date: 4/30/10

Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 144

0.00



Packaging

Memo

0.00

Packaging

10-5-4

sf

(10)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12

U 1005-04

Picklist Print

April 29, 2010 11:19:02 AM

Page 1

Work Order ID: 58218

Parent Item: D3262-043

Parent Item Name: Canister Assembly

Comments: IPP rev A 10.01.19 new issue EC verified by: DD

Start Date: 4/29/10

Required Date: 4/30/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3262-1		Manufactured	No			100	Each	4.0000	1			



Tube

Location

Loc Qty

Loc Code

LG
57657
WA
53504

2
2
2
2

[Handwritten signature]

1

BE 10/04/29

D3262-5 *Low E.*



Cap

Manufactured No

100 Each 6.0000 1



Location

Loc Qty

Loc Code

LG
57407

6
6

[Handwritten signature]

1

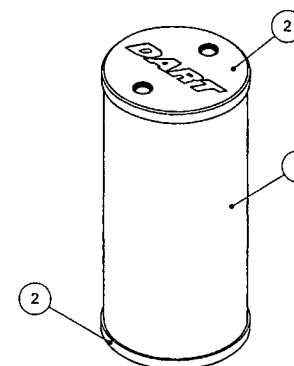
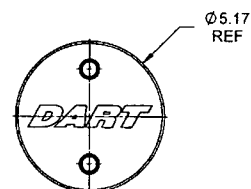
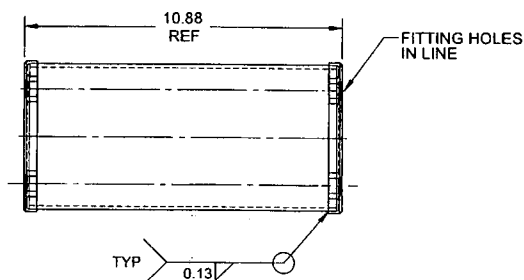
> BE 10/04/29

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B 58148

1

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



D3262-041 CANISTER ASSEMBLY

W/S 58215

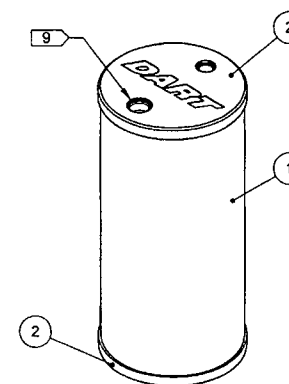
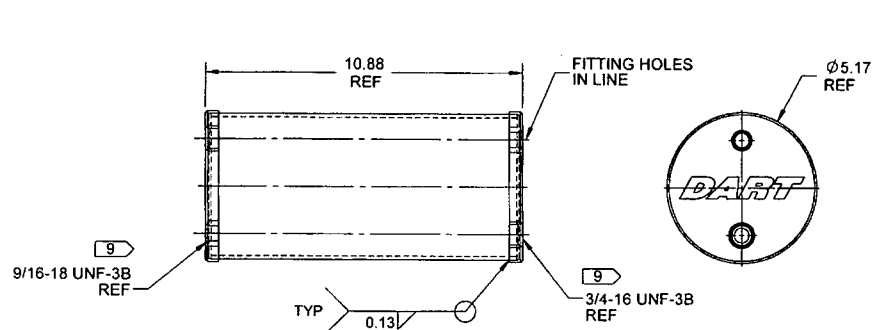
RELEASED
2010-01-14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.56 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

D	ADD D3262-043/-5 (ZN B5-2, B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4, C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3262	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FUEL PURGE CANISTER	NTS
DATE	09.12.30	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP



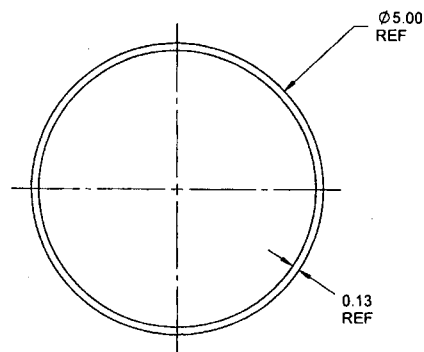
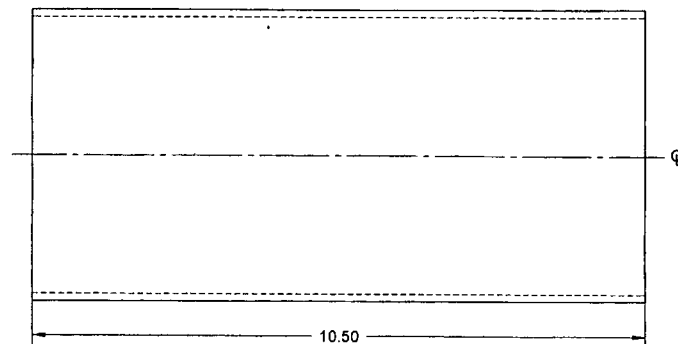
D3262-043 CANISTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.55 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>RF</i>	D3262	SHEET 2 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	FUEL PURGE CANISTER	NTS
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2010-01-14
MP



D3262-1 TUBE

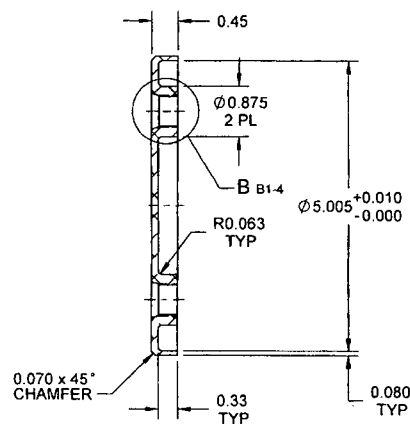
W/S 50218

RELEASED
2010-01-14
MP

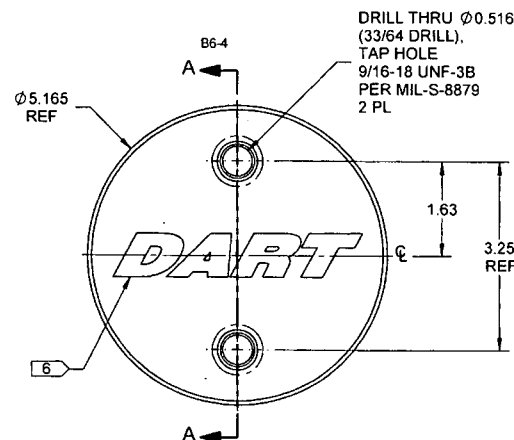
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

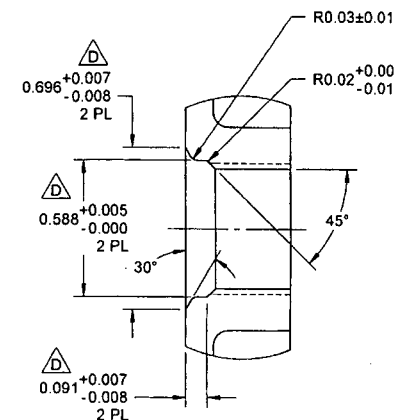
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DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D3262	REV. D
MFG. APPR.	<i>RF</i>		SHEET 3 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	FUEL PURGE CANISTER	NTS
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SECTION A-A C5-4



D3262-3 CAP



**DETAIL B C7-4
SCALE 2X**

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.30 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D3262	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
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2010-01-14
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